

Date: Tuesday, 10/02/2009 11:09:12 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 45669		
Estimate Number	: 12437		
P.O. Number	:	Part Number	: D35181
This Issue	: 10/02/2009 S.O. No. :	Drawing Number	: D3518 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 38934	Material	:
Written By	:	Due Date	: 28/02/2009 Qty: 10 Um: Each
Checked & Approved By	: <u>JUD 09.02.10</u>		
Comment	: Est Rev:A New Issue 06-11-20 JLM est rev B rev B dwg 07.04.09 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6H0875	6061-T6 HexBar .875
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Comment: Qty.: 1.1550 f(s)/Unit Total: 11.5500 f(s)
 6061-T6 7/8" HexBar
 Batch: M110980

ml 09/02/28

(10)

2.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE
 Turn as per Dwg D3518,

1-Face to Length and Drill & Tap.

ml 09/02/28

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09/02/28

(10)

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Drill as per Dwg D3518.

1-Drill 2x .191" holes & 1x .0625" hole

ml 09/02/28

(10)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09/02/28

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STRUT

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

88 09/03/03

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MDX BK

(X10)
09/03/03

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

*****Mask threads with AN6 bolt*****

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

10:10

OVEN TEMPERATURE:

320°

FINISH TIME:

10:40

(18)
FD 09/03/04

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

04-03-04 (X10)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST271

SS 09/03/05 (X10)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/05

Job Completion



U 09.03.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

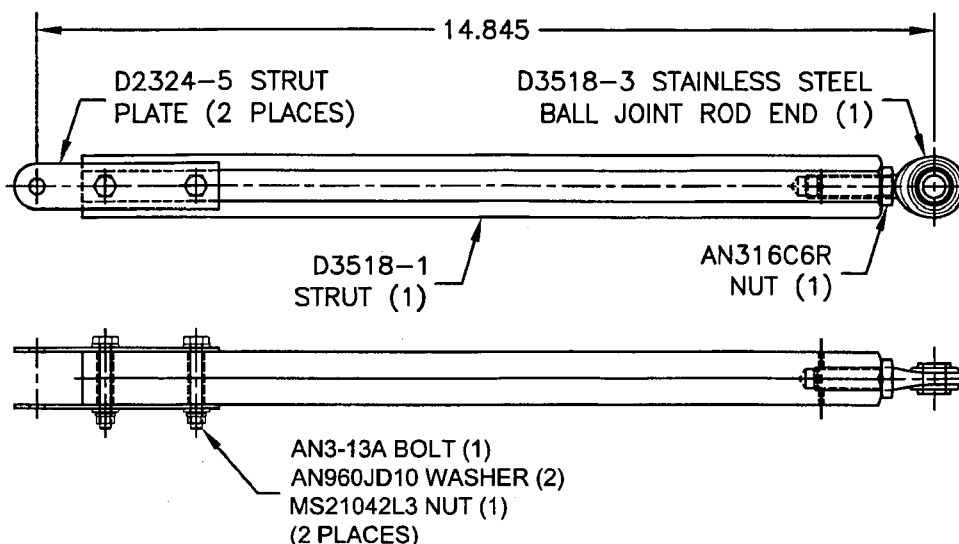
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 1 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:3
A	06.06.21	NEW ISSUE	
B	06.10.23	RE-DESIGN	



D3518-041 STRUT ASSEMBLY

QTY -041	Part Number	Description
X	D3518-041	STRUT ASSEMBLY
2	D2324-5	STRUT PLATE
1	D3518-1	STRUT
1	D3518-3	STAINLESS STEEL BALL JOINT ROD END
2	AN3-13A	BOLT
1	AN316C6R	NUT
4	AN960JD10	WASHER
2	MS21042L3	NUT

NOTES:

- 1) IDENTIFY WITH DART P/N "D3518-041" USING FINE POINT PERMANENT INK MARKER

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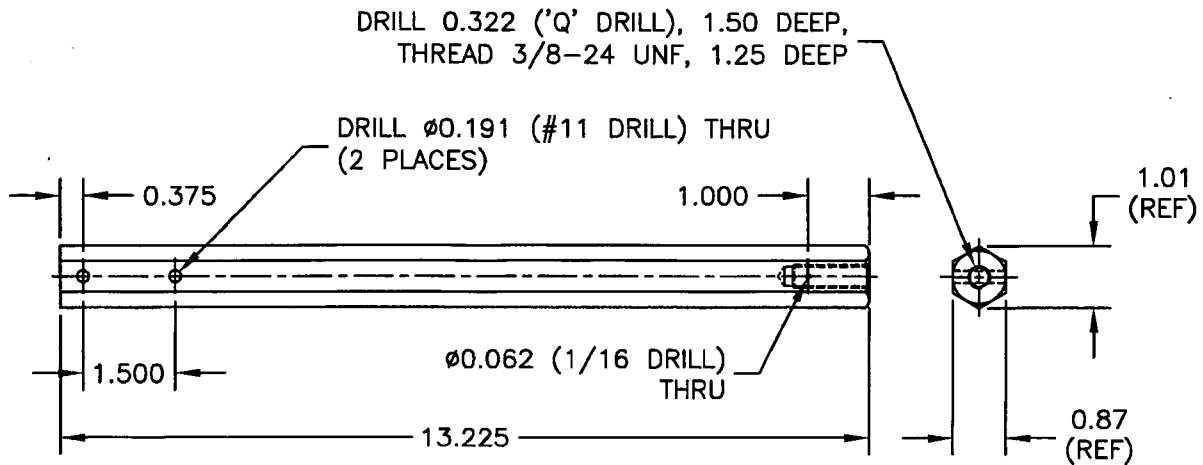
06.11.17 *[Signature]*

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DART

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 2 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:3

**D3518-1 STRUT****NOTES:**

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM HEX BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART MATERIAL SPEC M6061T6H0.875)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

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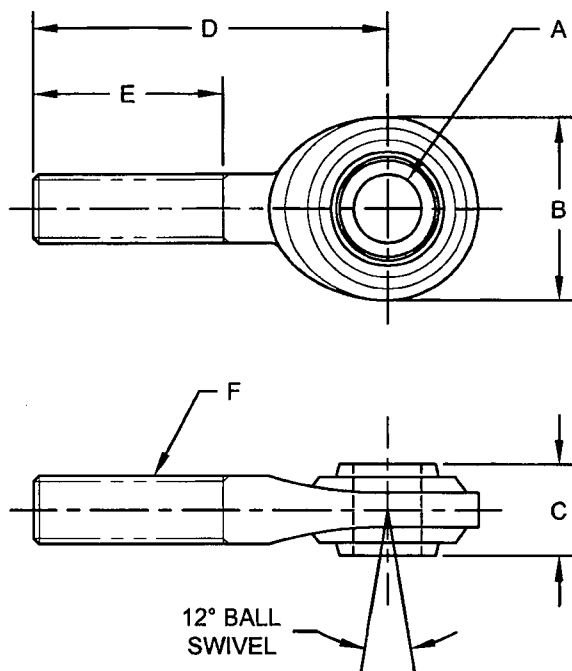
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 3 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:1

SPECIFICATION CONTROL DRAWING



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NO. *45669*

DART P/N	A	B	C	D	E	F	LOAD*	POSSIBLE SUPPLIER
D3518-3	0.375	1.00	0.50	1.938	1.25	3/8-24 UNF, RH	4012	McMASTER-CARR, P/N 2458K14

* Indicated load is Static Radial Load Capacity in lbs

NOTES:

- 1) TYPE: MALE THREADED SHANK CARBON-FIBER-REINFORCED PLASTIC RACE BALL JOINT ROD END
- 2) MATERIAL: ZINC PLATED STEEL HOUSING BALL WITH PTFE LUBRICATED CARBON-FIBER-REINFORCED PLASTIC RACE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.11.17 *[Signature]*

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